

Work Order ID 149790***149790***

Page 1

Item ID: PB67-43001-63

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Handle Assy

Stop ***NS2***

Start Date: 8/2/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/12/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: SU Date: 8/2/16

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-63	Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.17

Large Fab

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg
- 9- assemble by drilling thru both -157 and -133 as per dwg
- 10- install spring slotted pin as per dwg

2

AUG 03 2016

DAS
24
9-89

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

2

AUG 03 2016

DAS
43
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 149790

August 02, 2016 3:27:43 PM

149790

Page 2

Item ID: PB67-43001-63 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Assy
 Start Date: 8/2/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/12/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				2	AUG 03 2016	DAS 43 9-89	
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo ****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat**** START TIME: 2:00 PM OVEN TEMPERATURE: 320°F FINISH TIME: 2:30 PM	0.00 0.01				2x		ALL 16/08/17	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2		DAS 38 9-89 AUG 23 2016	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 149790

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149790

Page 3

Item ID: PB67-43001-63

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Assy

Start Date: 8/2/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/12/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: MEZZA 0.00***150***

Packaging

Memo

0.00

2

AUG 24 2016

DAS
24
9-89

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.03

DAS
21
9-89

AUG 24 2016

Quality Control

DAS
21
9-89

AUG 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
240 AS 08-0 2105 AS 08-0 240 AS 08-0									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 149790

149790

Parent Item: PB67-43001-63

PB67-43001-63

Parent Item Name: Handle Assy

Start Date: 8/2/2016

Required Date: 8/12/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
10.09.30 per rev C dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-129		Manufactured	No			100	Each	4.0000	1	2		AUG 03 2016	DAS 24 9-89
PB67-43001-129									**				
Tube Handle													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				4					
				139140				4		2			
PB67-43001-127		Manufactured	No			100	Each	5.0000	1	2		AUG 03 2016	DAS 24 9-89
PB67-43001-127									**				
Handle Arm													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				5					
				139141				5		2			
PB67-43001-157		Manufactured	No			100	Each	5.0000	1	2		AUG 03 2016	DAS 24 9-89
PB67-43001-157									**				
Tube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				5					
				147170				5		2			
PB67-43001-131		Manufactured	No			100	Each	17.0000	2	4		AUG 03 2016	DAS 24 9-89
PB67-43001-131									**				
Tube End Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				1					
				139142				1		1			
				WA002				16					
				142653				16		3			

Picklist Print

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Page 2

Work Order ID: 149790

149790

Parent Item: PB67-43001-63

PB67-43001-63

Parent Item Name: Handle Assy

Start Date: 8/2/2016

Required Date: 8/12/2016

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-133

Manufactured No

100 Each

6.0000

1 2

PB67-43001-133

Clevis

**

AUG 03 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

6

133721

2

139143

4

240-107

Purchased No

100 Each

168.0000

1 2

240-107

SPRING SLOTTED PIN

**

AUG 03 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

ST579

168

m132006

24

m134651

144

CR3213-4-2

Purchased No

100 Each

194.0000

1 2

CR3213-4-2

Cherry Rivet

**

AUG 03 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

CCK003

100

m134058

100

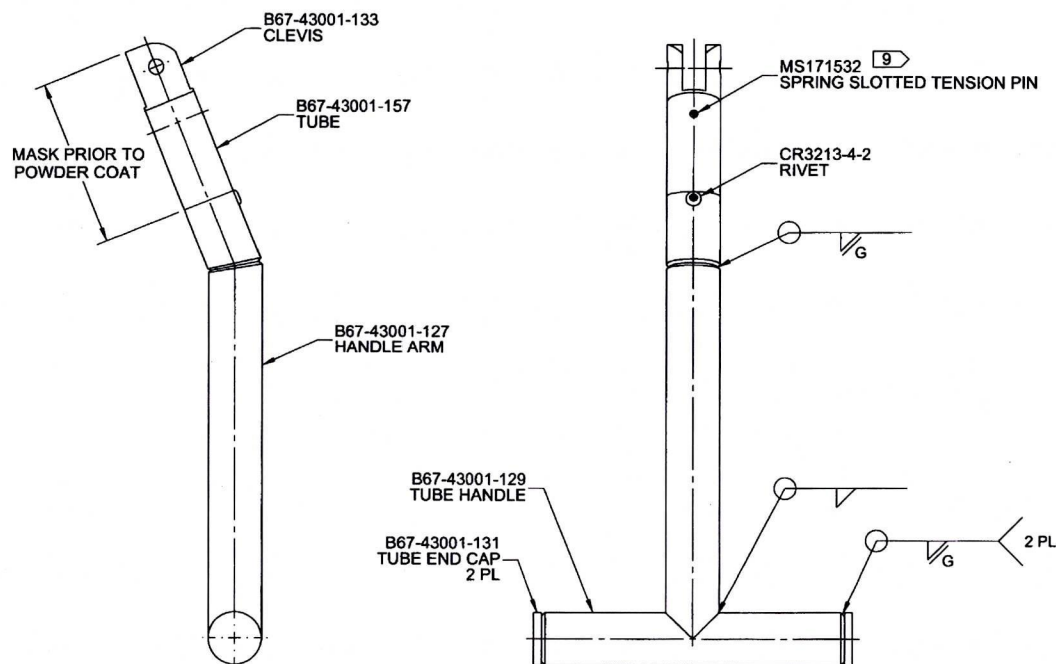
ST320

94

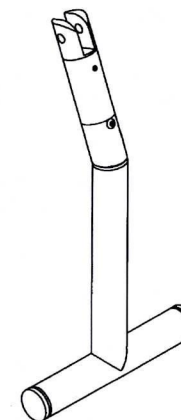
123301

94

149790
542 8/2/16



B67-43001-63 SHORT T-HANDLE ASSEMBLY



RELEASED
2010-09-16
JMP

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs
- 8) WELDING: PER DART QSI 004
- 9) ALIGN B67-43001-133 AS SHOWN. ENLARGE PILOT HOLE LOCATED ON HANDLE AND DRILL THRU B67-43001-157-133. DRIVE MS171532 IN TO HOLE.

ITEM	QTY -63	P/N	DESCRIPTION
1	X	B67-43001-63	SHORT T-HANDLE ASSEMBLY
3	1	B67-43001-129	TUBE HANDLE
4	1	B67-43001-127	HANDLE ARM
5	1	B67-43001-157	TUBE
6	2	B67-43001-131	TUBE END CAP
7	1	B67-43001-133	CLEVIS
9	1	MS171532	SPRING SLOTTED TENSION PIN (OR 240107)
10	1	CR3213-4-2	RIVET

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 1 OF 1	
DRAWN				
CHECKED	JIS	DRAWING NO.	SCALE	
MFG. APPR.		B67-43001-63		
APPROVED	N/A	TITLE	SHORT T-HANDLE ASSEMBLY NTS	
DE APPR.				
DATE	09.06.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		